

SHIP ~~REEST~~ LATEST 20/07

PRELIMINARY ISSUE

Work Order ID 50557

July 15, 2009 11:22:27 AM

Item ID: D3937-3
Revision ID: A-Prelim
Item Name: Backing Strip

Accept



Setup Start



Stop



Start Date: 7/15/09 Start Qty: 300.00
Required Date: 7/20/09 Req'd Qty: 300.00



Cust Item ID:
Customer:



Reference:

Approvals: Process Plan:
QC:

[Signature]

Date: Tooling:
Date: SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
Waterjet		0.00							
FLOW CNC Waterjet	Memo 1-Cut as per Dwg Dwg Rev: <u>PRE</u> Prog Rev: <u>Lim</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

M-h 09/07/21 (303X)
POSITIVE RECALL
EFFECTIVE 09/07/21 AUTH *[Signature]*
RELEASED DATE 09/07/21
M-h 09/07/21 (303X)
B 9-7-21

Tested & seal
Per DS & Hawley

Work Order ID 50557

July 15, 2009 11:22:27 AM



Page 2

Item ID: D3937-3

Accept



Setup Start



Revision ID: A-Prelim

Stop



Item Name: Backing Strip

Start Date: 7/15/09

Start Qty: 300.00



Cust Item ID:

Required Date: 7/20/09

Req'd Qty: 300.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

303

counted in batches of 20

105721

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

303 X
counted

M-L 09/07/22

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

303

BL 09-07-22

Work Order ID 50557

July 15, 2009 11:22:27 AM

Page 3

Item ID: D3937-3

Accept

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Start Date: 7/15/09

Start Qty: 300.00

Required Date: 7/20/09

Req'd Qty: 300.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

Per 7/22 303

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

07/16/09

FOR ENG USE
ONLY
TESTED & SCRAP
PER DS &
HARVEY.

U 9.07.23

Picklist Print

July 15, 2009 11:25:43 AM

Page 1

Work Order ID: 50557

Parent Item: D3937-3A-Prelim

Parent Item Name: Backing Strip

Comments:

Start Date: 7/15/09

Required Date: 7/20/09

Start Qty: 300.00

Required Qty: 300.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No				sf	102.1700	29.5200			



6061-T6 Sheet 0.032"

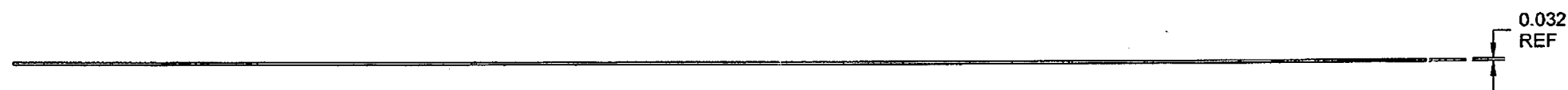
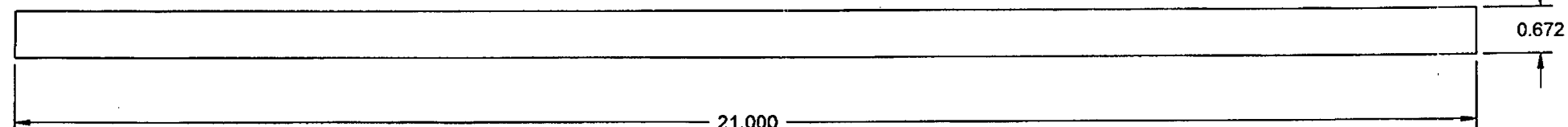
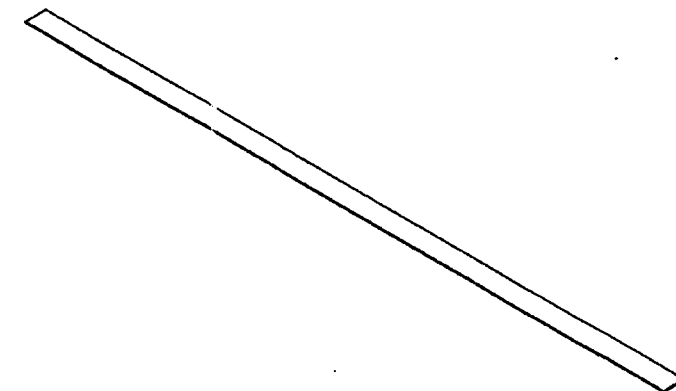


<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	102.17	
110063	38.78	
16954	8.99	
18375	54.4	

110063 9-7-20

PRELIMINARY ISSUE

NP 09/06/06



D3937-3 SHEET METAL BACKING STRIP

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.032 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. A
MFG. APPR.	E	D3937	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUMINESCENT STRIP	NTS
DATE	09.06.02	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Jason Murdoch

From: Harvey Siemens [hsiemens@dartaero.com]
Sent: July 21, 2009 3:42 PM
To: 'Jason Murdoch'
Cc: 'L Lacelle'; 'Melanie Fauteux '
Subject: RE: Prelim D3937-3 metal backings

Wow

I hope we didn't put 21.000" on the drawing. It should be 21.0", maybe even 21".

Not a problem for the numbers you gave me.

Regards,

Harvey Siemens

Mechanical Designer
DART Aerospace Ltd.

P: 403-717-0328
F: 403-717-1288
E: hsiemens@dartaero.com
W: www.dartaero.com

M: 1060 McTavish Road NE, Calgary, Alberta, T2E 5G9

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From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: Tuesday, July 21, 2009 1:36 PM
To: 'Harvey Siemens'
Cc: 'L Lacelle'; 'Melanie Fauteux '
Subject: Prelim D3937-3 metal backings
Importance: High

Hi Harvey Bhoi,

The 21.000" long dimension varies a lot on the D3937-3 strips. The majority of them are 21.000" long, but quite a few dims vary from 20.93" to 21.05". Any chance these would be acceptable?

Jason Murdoch
Quality Coordinator
jmurdoch@dartaero.com

21/07/2009

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3937-041	LUMINESCENT STRIP ASSEMBLY
2	1	D3937-1	LUMINESCENT STRIP
3	1	D3937-3	SHEET METAL BACKING STRIP

PEEL SELF-ADHESIVE BACKING FROM
D3937-1 LUMINESCENT STRIP
ALIGN PART EDGES AND STICK TO
D3937-3 SHEET METAL BACKING STRIP

D3937-041 LUMINESCENT STRIP ASSEMBLY

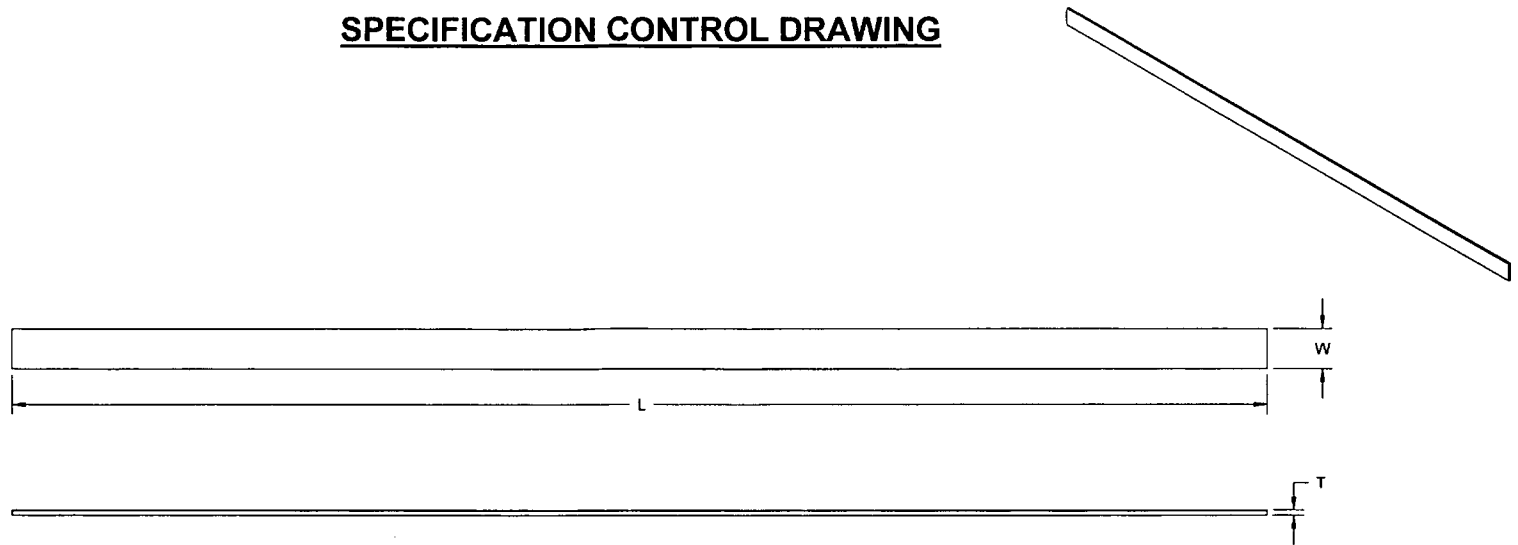
50557

RELEASED
2009-08-28
M

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3937-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.06 lbs

A	NEW ISSUE	BY	09.06.02
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.		D3937	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUMINESCENT STRIP	NTS
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SPECIFICATION CONTROL DRAWING



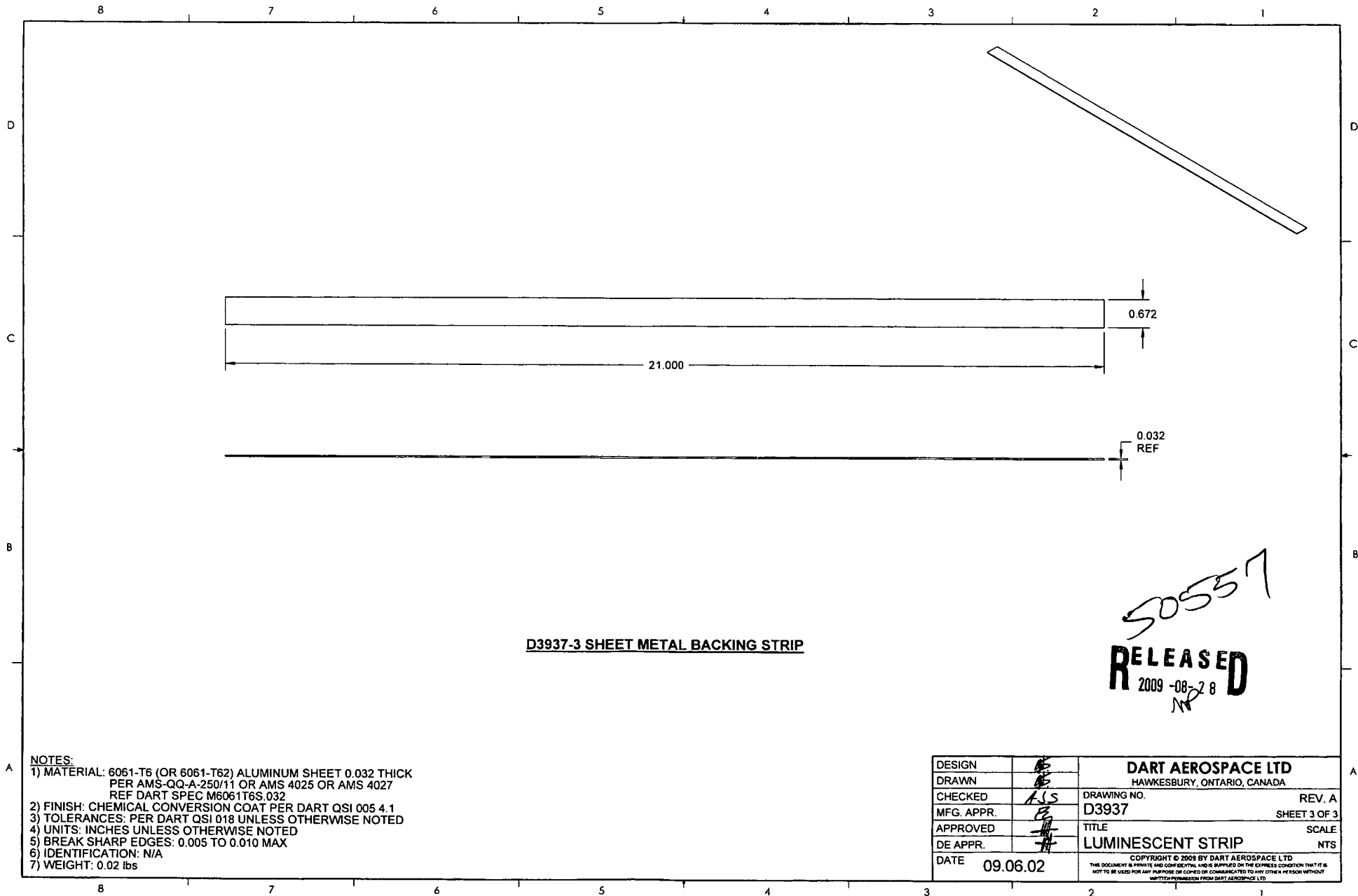
D3937-1 LUMINESCENT STRIP

DART PART NUMBER	LENGTH "L"	WIDTH "W"	THICKNESS "T"	SUPPLIER	SUPPLIER PART NUMBER	WEIGHT
D3937-1	21.0	0.67	0.09	LUFTHANSA TECHNIK	PL88-990LH00	0.04 LBS

50557
RELEASED
 2009-08-28

- NOTES:
 1) MATERIAL: SEE TABLE
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: SEE TABLE

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CHECKED	<i>ASS</i>	DRAWING NO.	REV. A
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUMINESCENT STRIP	NTS
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CHECKED	<i>AJS</i>	DRAWING NO.	REV. A
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2009-08-28
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